Α

Page 1

July 13, 2009 12:27:08 PM

Item ID:

D3020-1

Accept

Setup Start

Stop



Revision ID: Item Name: Fitting

Required Date: 7/15/09

7/15/09

Start Qty: 40.00 Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Run

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours** Draw Number Draw Rev.

Plan

Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3020

Rev A

Hardinge

Hardinge CNC LATHE SMALL

Memo

Memo

0.00

Hardinge CNC Lathe Small

Turn blank as per Folio FA255 and Dwg D3020

110

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

1 9.07.15

Quality Control

120

Small Fab

A .4. 07.14 (41)

Small Fab

Small Fab

Memo Deburr 0.00

Dart Aerospac	e Ltd	
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W/O:	W/O: WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	.:	_ Date: _		
	R	esolution:	Disposition	:	QA: N/C CI	osed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)				
DATE	STEP	Description of NC		n B	Verifica	Verification	Approval	Approval		
DAIL		STEP Description Section	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
	1				1			1		

NOTE: Date & initial all entries

Α

Page 2

Item ID:

D3020-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Fitting

Required Date: 7/15/09

July 13, 2009 12:27:08 PM

7/15/09

QC:

Start Oty: 40.00 Req'd Qty: 40.00

Cust Item ID:

Customer:

Draw

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start



Date:

SPC (Y/N):

Date:

Stop

Run

Sequence ID/ Work Center ID

130

Quality Control

Operation Description

QC8- Inspect parts - second check

Set Up/ **Run Hours**

Number 5/1 09/01/20

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

0.00

0.00

140

Packaging Packaging

Packaging

Memo

0.00

0.00

Identify and bag with light oil (Vactra oil #2), then Stock (Location)

150

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/2018 US9.07.W

Dart Aer	ospace	Ltd
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W/O:			RK ORDER CHAN	GES				·		
DATE	STEP	PR	OCEDURE CHA	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DC)A:	Date: _		
Resolution: D				າ:	QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORM	IANCE (NO	R)	-			
DATE	STEP	Description of NC			ction B	Verif	ication	Approval Chief Eng	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		Section C		QC Inspector	
								_		
									1	
							···- <u>-</u>			
									!	

NOTE: Date & initial all entries

Picklist Print

July 13, 2009 12:27:07 PM

Work Order ID: 50369

Parent Item: D3020-1RevA

Parent Item Name: Fitting

Comments:



Start Date: 7/15/09

Required Date: 7/15/09

09-07-15

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1018R1.250		Purchased	No			100	f	47.8000	3.7011			

1018 ROUND BAR 1.250

<u>Warehouse</u>	Loc Qty	Loc Code	
Location			
Main Warehouse			
MAT	47.8	D	
15925	34	24	717
16443	13.8	,	

100	A ara	space	1 44
ijari .		::::::::::::::::::::::::::::::::::::::	1 1/1
		, Duo	

W/O:				WORK ORDER CHANGES								
DATE	STEP		PRO	ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							•					
								-				
Part No	:		_ PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date: _			
	Re	esolution:		Disposition:	QA: N	NC C	losed:		Date:			

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	·····	Verification	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
				,				
								
				•				

* NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50369
Description: Fitting	Part Number:	D3020-1
Inspection Dwg: D3020 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.010	1.25				
0.030 x 45°	+/-0.010	.03×45°				
0.640	+0.000/-0.010	. 635				
0.930	+/-0.010	-730				
0.125	+/-0.010	.125				
0.300	+/-0.010	, 300				
0.844	+/-0.010	, 844				
1.030	+/-0.010	1.028				
Ø0.750	+0.005/-0.000	.752				
0.200	+/-0.010	. 200				

Measured by:	Audited by: S		Prototype Approval:	N/A
Date: 09.07.15	Date: O	107/20	Date:	N/A

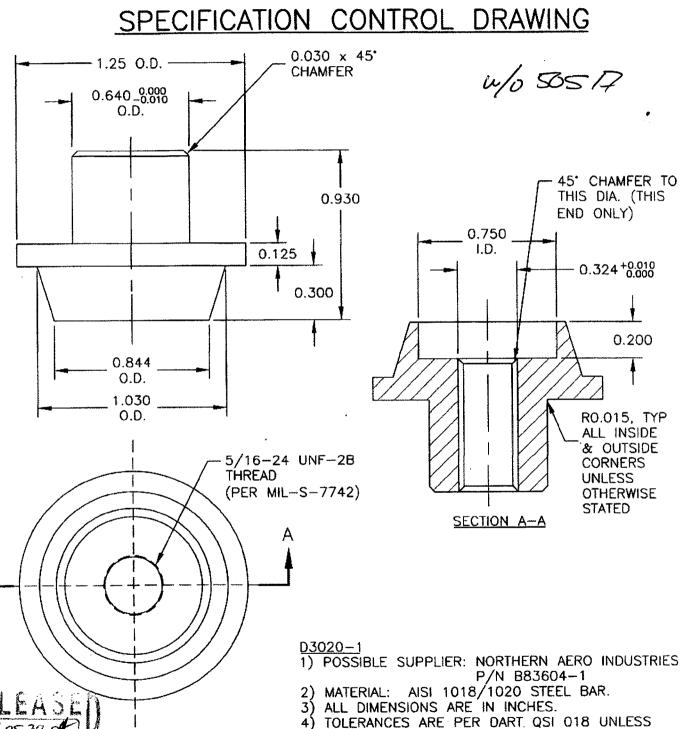
Rev	Date	Change	Revised þy	Approxed
Α	05.04.26	New Issue	KJ/JLM of	





)	DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHECKE	4	APPROVED	DRAWING NO. D3020	REV. A SHEET 1 OF 1	
	DATE			TITLE	SCALE	
	01.05.18			FITTING	2:1	
	Δ		01 05 18	NEW ISSUE		

SPECIFICATION CONTROL



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